

Work Order ID 63376

Page 1

Thursday, October 28, 2010 10:21:37 AM

Item ID: D206-642-541

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 10/28/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 11/11/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

10-10-25

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
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Draw Nbr

Revision Nbr

D3274

D

IIN-D206-642

Rev M

100

0.00



DOCUMENT CONTROL

DC

0.00

Memo

Document Control

Photocopy bluefile & type labels per PPP D206-642-541

CHG003

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

110

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

****VERIFY AND INSPECT THE MATERIAL PRIOR TO USE****

1- Bend FWD end of tube using bend prog D3274 FWD and foil 10 as per dwg D3274, cut fwd end of tube with saw table setup D3274.

SAD 10-11-03

2- remove fwd indexing ridge as per dwg D3274. Prepare for welding

BE 10-11-04

3- weld fwd cap as per dwg D3274 and OS1004

AR Aluminum Rod Batch:

M11385/M115778

BE 10-11-04

4- grind fwd cap weld on top surface only

BE 10-11-04

5- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end.

6-Drill Aft cap pilot hole using DT8025

7 -Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D.
Drill 3/16" pilot holes as per Dwg D3274

BE 10/11/04

8 -Remove inner indexing ridge on aft end of skidtube as per Dwg D3274 scribe batch #

9 -Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|----------------------|---------|-----------|--------------|---------------|---------------|------------------|----------------|
| 120 HandFinish Hand Finishing | Chemical Conversion Coat per QS1005 4.1 Memo | 0.00 0.00 | | | | 1 | | | BB 10/11/09 |
| 130 QC Quality Control | QC3- Inspect Part Finish Memo | 0.00 0.00 | | 8 vltalor | | | | | |
| 140 QC Quality Control | QC5- Inspect part completeness to step on W/O Memo | 0.00 0.00 | | 8 vltalor | | | | | Ⓣ |

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Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Open Ø0.313" and 0.375" crossbolt spacer holes as per Dwg D3274

2-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube

3-Bond web in place as per Dwg D3274 & QSI 015.

A/R ☐ Sikaflex-291 ☐ 1116040 ☐

Sikaflex expire date: ☐ 11-9-30

Start: ☐ 10-11-15 Time: ☐ 1PM

Finish: ☐ 10/11/16 Time: ☐ 5:30am

(Adhere for 12 hours)

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/16

10-11-15

10/11/10

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

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| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 170 | Skidtubes | 0.00 | | | | | | | |
| Skidtubes | Memo | 0.00 | | | | | | | |
| Skidtubes | 1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt spacer holes to maintain web position. | | | | | | | | BE 10/11/10 |
| | 2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2 OPEN HOLES TO .297" . Deburr | | | | | | | | |
| | 3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD END OF TUBE DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES) REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES | | | | | | | | BB 10/11/17 |
| | 4- Countersink crossbolt spacer holes as per Dwg D3274 | | | | | | | | |
| | 5- prepare for welding | | | | | | | | |
| 180 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | 70 |

L 4.9"

h=3.0"

8/10/17

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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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|----------------|----------------------|------------|------|-------|---------------|--|
| Item ID: | D206-642-541 | Accept | | Setup | Start | |
| Revision ID: | | | | | Stop | |
| Item Name: | Replacement Skidtube | | | | | |
| Start Date: | 10/28/2010 | Start Qty: | 1.00 | | Cust Item ID: | |
| Required Date: | 11/11/2010 | Req'd Qty: | 1.00 | | Customer: | |
| Reference: | | | | | | |

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|------------|---------------|-------|------------|-------|-----|-------|--|
| Approvals: | Process Plan: | Date: | Tooling: | Date: | Run | Start | |
| | QC: | Date: | SPC (Y/N): | Date: | | Stop | |

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 190 | | 0.00 | | | | | | | |
| | Skidtubes | | | | | | | | |
| Skidtubes | Memo | 0.00 | | | | | | | |
| Skidtubes | 1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod A/R <input type="checkbox"/> Aluminum Rod <input checked="" type="checkbox"/> <i>M111385 BE 10/11/18</i> | | | | | | | | |
| | 3-Grind cross bolt welds flush as per Dwg D3274. | | | | | | | | |
| | 4-Counterbore 5/16" x 0.750" deep as per Dwg D3274 and deburr. | | | | | | | | |
| | | | | | | | | | |
| 200 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

BE 10/11/18
BE 10/11/18
8 10/11/18

(70)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

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|----------------|----------------------|------------|------|-------|---------------|--|
| Item ID: | D206-642-541 | Accept | | Setup | Start | |
| Revision ID: | | | | | Stop | |
| Item Name: | Replacement Skidtube | | | | | |
| Start Date: | 10/28/2010 | Start Qty: | 1.00 | | Cust Item ID: | |
| Required Date: | 11/11/2010 | Req'd Qty: | 1.00 | | Customer: | |
| Reference: | | | | | | |

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|------------|---------------|-------|------------|-------|-----|-------|--|
| Approvals: | Process Plan: | Date: | Tooling: | Date: | Run | Start | |
| | QC: | Date: | SPC (Y/N): | Date: | | Stop | |

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|----------------------|---------|-------------|--------------|---------------|---------------|------------------|----------------|
| 210 QC Quality Control | QC10- Inspect visual per QSI004- ground welds Memo | 0.00 0.00 | | 8 10/11/23 | | | | | |
| 220 HandFinish Hand Finishing | Pressure Wash per QSI005 4.3 Memo Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch | 0.00 0.00 | | 20 10/11/23 | | 1 | | | |
| 230 Powdercoat Powder Coating | White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 1115591 Memo START TIME: 9:00 OVEN TEMPERATURE: 320 FINISH TIME: 9:30 | 0.00 0.00 | | | | 1 | | 10-11-26 | |

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|--------------------------------|--|----------------------|---------|----------|--------------|---------------|---------------|------------------|----------------|
| 240 | QC3- Inspect Part Finish | 0.00 | =7 JH | 10/11/29 | | xl | Ø | | |
| QC Quality Control | Memo | 0.00 | | | | | | | |
| 250 | HandFinishing | 0.00 | =7 JH | 10/11/29 | | xl | Ø | | |
| HandFinish Hand Finishing | Memo ✓ 1-Install Nut Plate as per Dwg D3274. Apply LPS-3 to Nut Plate and rivets. A/R <input type="checkbox"/> N/A <input type="checkbox"/> LPS-3 <input type="checkbox"/> M109936 2-Install inserts as per Dwg D3274. Use a drop of Sikaflex inside insert holes a A/R <input type="checkbox"/> Sikaflex-291 <input type="checkbox"/> M115114 Sikaflex expire date: <input type="checkbox"/> 11/10/11 | 0.00 | | | | | | | |
| 260 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| QC Quality Control | Memo Inspect Nut Plate & Inserts | 0.00 | | | | | | | ml 10 11 29 13 |

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Run Start



Stop



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|---|---|----------------------|---------|------------|--------------|---------------|---------------|------------------|----------------|
| 270 HandFinish Hand Finishing | HAND FINISHING RESOURCE #1 Memo 1-Install wearpads & gaskets as per Dwg D3274. 2-Install ring as per Dwg D3274 A/R <input type="checkbox"/> Sikaflex-291 <input checked="" type="checkbox"/> 11/15/10 Sikaflex expire date: <input type="checkbox"/> 11/01 3-Inspect for foreign objects as per QSI 024 4-Spray inside of tube on both sides of web with LPS-3 A/R LPS-3 Batch: N/A 5-Install Aft Cap and seal with Sikaflex. Clean excess adhesive. A/R <input type="checkbox"/> Sikaflex-291 <input checked="" type="checkbox"/> 11/15/10 Sikaflex expire date: <input type="checkbox"/> 11/01 | 0.00 0.00 | | 10112110 | | 1 | 0 | | |
| 280 QC Quality Control | QC5- Inspect part completeness to step on W/O Memo | 0.00 0.00 | | 8 10/17/13 | | | | | (X) |

Dart Aerospace Ltd

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| 290 Packaging Packaging | Identify as per dwg & Stock Location: _____ Memo | 0.00 0.00 | | 363385 | | | | 10/12/13 | JP |
| 300 QC Quality Control | QC21- Final Inspection - Work Order Release Memo | 0.00 0.00 | | | | | | 10/12/14 | JP |

u 10/12.14

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Picklist Print

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Work Order ID: 63376

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube



Start Date: 10/28/2010

Required Date: 11/11/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:B 05.09.23 Revised per D206-642 Rev. J KJ/JLM
 IPP Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM
 IPP Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD
 IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC
 IPP Rev:F 08-06-02 add comment DD verified by:EC
 IPP Rev:G 08-10-09 revise details DD verified by:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

D2600-1-190

Manufactured

No

110

Each

63.0000

1

1



Extrusion Round 3" 206



SAD 10-11-03

Location

Loc Qty

Loc Code

LG

63

47575

15

59874

48

D3285-1

Manufactured

No

110

Each

141.0000

1

1



Cap



Location

Loc Qty

Loc Code

LG

141

52511

74

52647

67

D3282-041

Manufactured

No

150

Each

0.0000

1

1



Float Web (206L/407)



B63390

①

BR 10-11-04
 DP 10-11-15

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

Thursday, October 28, 2010 10:21:42 AM

Page 2

Work Order ID: 63376

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 10/28/2010

Required Date: 11/11/2010

Start Qty: 1.00

Required Qty: 1.00

D2649 Manufactured No 190 Each 107.0000 12 12



Cross Bolt Spacer

Location

Loc Qty

Loc Code

| | |
|-------|-----|
| LG | 107 |
| 58545 | 2 |
| 60652 | 4 |
| 61496 | 13 |
| 62889 | 88 |



8 6335 9 12 BE 10/11/17

D3275-1 Manufactured No 190 Each 216.0000 12 12



Crossbolt Spacer

Location

Loc Qty

Loc Code

| | |
|-------|-----|
| LG | 216 |
| 53453 | 8 |
| 61646 | 102 |
| 62399 | 106 |



12 BE 10/11/17

CR3212-4-03 Purchased No 250 Each 1,874.000 2 2



Cherry Rivet

Location

Loc Qty

Loc Code

| | |
|--------|------|
| ST311 | 1874 |
| 111359 | 5 |
| 112314 | 2 |
| 114436 | 448 |
| 114450 | 71 |
| 114859 | 1348 |



12 BE 10/11/17

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

Picklist-Print

Thursday, October 28, 2010 10:21:42 AM

Page 3

Work Order ID: 63376

Parent Item: D206-642-541



Parent Item Name: Replacement Skidtube

Start Date: 10/28/2010

Required Date: 11/11/2010



Start Qty: 1.00

Required Qty: 1.00

| | | | | | | | |
|---|--------------|----|-----|------|---------|---|--------------------|
| D3415-041 | Manufactured | No | 250 | Each | 52.0000 | 1 | 1 |
|  | | | | | |  | <u>yl 10/11/29</u> |
| Nut Plate | | | | | | | |



| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
|-----------------|----------------|-----------------|

| | | |
|--------------|----|--|
| ST056 | 52 | |
| <u>33842</u> | 52 | |

| | | | | | | | |
|---|-----------|----|-----|------|----------|---|--------------------|
| CCR264SS3-3 | Purchased | No | 250 | Each | 416.0000 | 2 | 2 |
|  | | | | | |  | <u>yl 10/11/29</u> |
| Cherry Rivet | | | | | | | |

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
|-----------------|----------------|-----------------|

| | | |
|---------------|-----|--|
| ST311 | 416 | |
| 112314 | 4 | |
| 113539 | 44 | |
| <u>113973</u> | 368 | |

| | | | | | | | |
|--|-----------|----|-----|------|-----------|---|--------------------|
| ALS4-1032-130 | Purchased | No | 250 | Each | 2,653.000 | 78 | 78 |
|  | | | | | |  | <u>yl 10/11/29</u> |
| Insert | | | | | | | |

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
|-----------------|----------------|-----------------|

| | | |
|--------|------|--|
| PKG11 | 886 | |
| 114723 | 886 | |
| ST282 | 1728 | |
| 110511 | 10 | |
| 115911 | 1718 | |
| ST381 | 39 | |
| 114654 | 39 | |

1116044 y78

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

Thursday, October 28, 2010 10:21:42 AM

Page 4

Work Order ID: 63376

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 10/28/2010

Required Date: 11/11/2010

Start Qty: 1.00

Required Qty: 1.00

D3536-15 Manufactured No 270 Each 18.0000 1 1
Gasket
10/12/09

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| FP | 6 | B63568 |
| 56055 | 1 | |
| 60875 | 5 | |
| FP11 | 12 | |
| 59238 | 1 | |
| 62459 | 11 | |

D3536-23 Manufactured No 270 Each 3.0000 1 1
Gasket
10/12/09

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| FP011 | 3 | B63570 |
| 61237 | 3 | |

D3536-35 Manufactured No 270 Each 16.0000 1 1
Gasket
10/12/09

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| FP012 | 16 | B63579 |
| 58683 | 1 | |
| 61692 | 3 | |
| 62462 | 12 | |

D3536-39 Manufactured No 270 Each 12.0000 1 1
Gasket
10/12/09

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| FP12 | 12 | B63578 |
| 58215 | 1 | |
| 58571 | 11 | |

Thursday, October 28, 2010 10:21:43 AM

Shop Packet Print

Page 4

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

Thursday, October 28, 2010 10:21:43 AM

Work Order ID: 63376

Parent Item: D206-642-541



Parent Item Name: Replacement Skidtube

Start Date: 10/28/2010

Required Date: 11/11/2010

Start Qty: 1.00

Required Qty: 1.00

| | | | | | | | |
|---|--------------|----|-----|------|---------|---|-----------------|
| D3535-15 | Manufactured | No | 270 | Each | 22.0000 | 1 | 1 |
|  | | | | | |  | <u>10/12/09</u> |
| Wearshoe | | | | | | | |

Location

Loc Qty

Loc Code

FP18

22

1363569

x1

61241



6

62241

3

62707

13

| | | | | | | | |
|---|--------------|----|-----|------|---------|---|-----------------|
| D3535-35 | Manufactured | No | 270 | Each | 26.0000 | 1 | 1 |
|  | | | | | |  | <u>10/12/09</u> |
| Wearshoe | | | | | | | |

Location

Loc Qty

Loc Code

FP018

26

13

60865



6

62461

12

62969

8

| | | | | | | | |
|--|--------------|----|-----|------|---------|--|-----------------|
| D3535-39 | Manufactured | No | 270 | Each | 27.0000 | 1 | 1 |
|  | | | | | |  | <u>10/12/09</u> |
| Wearshoe | | | | | | | |

Location

Loc Qty

Loc Code

FP18

27

60233

16

62945

11

x1

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

Thursday, October 28, 2010 10:21:43 AM

Page 6

Work Order ID: 63376

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 10/28/2010

Required Date: 11/11/2010

Start Qty: 1.00

Required Qty: 1.00

D3535-23

Manufactured No

270

Each

28.0000

1

1



Wearshoe



HL 10/12/09

Location

Loc Qty

Loc Code

FP

7

61830

6

FP021

21

60231

8

62706

13

D3537-3

Manufactured No

270

Each

40.0000

1

1



Wearpad



HL 10/12/10

Location

Loc Qty

Loc Code

FP17

40

60866

3

61674

17

62705

20

D3537-1

Manufactured No

270

Each

66.0000

9

9



Wearpad



HL 10/12/10

Location

Loc Qty

Loc Code

FP

1

55465

1

FP017

59

61986

15

62209

44

FP17

6

57713

3

60491

3

B63545

X9

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

Thursday, October 28, 2010 10:21:43 AM

Work Order ID: 63376

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 10/28/2010

Required Date: 11/11/2010

Start Qty: 1.00

Required Qty: 1.00

AN960C10L NAS1149C0332 Purchased No

270

Each

29.0000

80

80



10/12/10

washer

Location

Loc Qty

Loc Code

ST245

29

107534

29

M115832

x80

AN960C416 NAS1149C0463 Purchased No

270

Each

30.0000

1

1



10/12/10

washer

Location

Loc Qty

Loc Code

ST346

30

100993

30

M115358

x1

D3672-1 Manufactured No

270

Each

847.0000

2

2



10/12/10

Phenolic Washer

Location

Loc Qty

Loc Code

ST077

847

42329

150

52505

697

x2

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

Thursday, October 28, 2010 10:21:43 AM

Page 8

Work Order ID: 63376

Parent Item: D206-642-541


Parent Item Name: Replacement Skidtube

Start Date: 10/28/2010

Required Date: 11/11/2010

Start Qty: 1.00


Required Qty: 1.00

| | | | | | | | |
|---|-----------|----|-----|------|-----------|----|----|
| AN3C4A | Purchased | No | 270 | Each | 2,233.000 | 80 | 80 |
|  | | | | | | | |
| BOLT | | | | | | | |

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
|-----------------|----------------|-----------------|

| | | |
|--------|------|--|
| ST303 | 3 | |
| 115438 | 3 | |
| ST350 | 2230 | |
| 114108 | 14 | |
| 114416 | 12 | |
| 114523 | 2 | |
| 115300 | 202 | |
| 115589 | 1000 | |
| 115936 | 1000 | |


HL 10/12/10

| | | | | | | | |
|---|-----------|----|-----|------|----------|---|---|
| AN4C5A | Purchased | No | 270 | Each | 481.0000 | 1 | 1 |
|  | | | | | | | |
| BOLT | | | | | | | |

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
|-----------------|----------------|-----------------|

| | | |
|--------|-----|--|
| ST346 | 481 | |
| 110552 | 4 | |
| 112243 | 477 | |

HL 10/12/10

| | | | | | | | |
|--|--------------|----|-----|------|---------|---|---|
| D2646 | Manufactured | No | 270 | Each | 45.0000 | 1 | 1 |
|  | | | | | | | |
| Aft Cap | | | | | | | |

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
|-----------------|----------------|-----------------|

| | | |
|-------|----|--|
| FP-4 | 35 | |
| 57332 | 35 | |
| fp5 | 6 | |
| 62652 | 6 | |
| FP6 | 4 | |
| 52663 | 4 | |

HL 10/12/10

YI

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

Thursday, October 28, 2010 10:21:43 AM

Work Order ID: 63376



Parent Item: D206-642-541



Parent Item Name: Replacement Skidtube

Start Date: 10/28/2010

Required Date: 11/11/2010

Start Qty: 1.00

Required Qty: 1.00

D3413-1

Manufactured No

270

Each

23.0000

1

1



10/12/10

Ring

Location

Loc Qty

Loc Code

ST473

23

1362961

51586

1

53446

7

61322

15

81

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

DART**RELEASED**

07.02.12

DEO ATTACHED

| | | | |
|-------------------------------|--------------------------------|---|------------------------|
| DESIGN CP | DRAWN BY PH | DART AEROSPACE USA, INC. PORT HADLOCK, WA | |
| CHECKED [Signature] | APPROVED [Signature] | DRAWING NO. D3274 | REV. D SHEET 1 OF 4 |
| DATE 06.12.19 | | TITLE SKIDTUBE ASSEMBLY SCALE NTS | |
| A | 04.03.15 | NEW ISSUE | |
| B | 04.08.09 | MOVE SADDLE HOLE: 42.14 WAS 42.76 | |
| C | 05.03.16 | ADD -043; NEW INSERTS | |
| D | 06.12.19 | NEW INSERTS, SS WEARSHOE + GASKET | |

| Qty -041 | Qty -043 | Part Number | Description |
|-------------|-------------|---------------|---|
| X | | D3274-041 | SKIDTUBE ASSEMBLY |
| | X | D3274-043 | SKIDTUBE ASSEMBLY |
| 1 | 1 | D2600-1-240 | EXTRUSION |
| 1 | 1 | D2646 | AFT CAP |
| 12 | 12 | D2649 | CROSS BOLT SPACER |
| 12 | 37 | D3275-1 | CROSS BOLT SPACER |
| 1 | 1 | D3282-041 | FLOAT WEB |
| 1 | 1 | D3285-1 | CAP |
| 1 | 1 | D3413-1 | RING |
| 1 | 1 | D3415-041 | NUT PLATE |
| 1 | 1 | D3535-15 | WEARSHOE |
| 1 | 1 | D3535-23 | WEARSHOE |
| 1 | 1 | D3535-35 | WEARSHOE |
| 1 | 1 | D3535-39 | WEARSHOE |
| 1 | 1 | D3536-15 | GASKET |
| 1 | 1 | D3536-23 | GASKET |
| 1 | 1 | D3536-35 | GASKET |
| 1 | 1 | D3536-39 | GASKET |
| 9 | 9 | D3537-1 | WEARPAD |
| 1 | 1 | D3537-3 | WEARPAD |
| 78 | 78 | ALS7-1032-130 | INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130) |
| 80 | 80 | AN3C4A | BOLT |
| 1 | 1 | AN4C5A | BOLT |
| 1 | 1 | AN960C416 | WASHER |
| 80 | 80 | AN960C10L | WASHER |
| 2 | 2 | CCR264SS3-3 | RIVET |
| 2 | 2 | CR3212-4-03 | RIVET |
| 2 | 2 | NAS1515H3L | WASHER |

GENERAL NOTES:

1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
3. ALL HOLES DRILLED ON CENTERLINES.
4. BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINISH: - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1
- POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
7. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
8. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

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SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. **0-3374****B/P 01028**

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

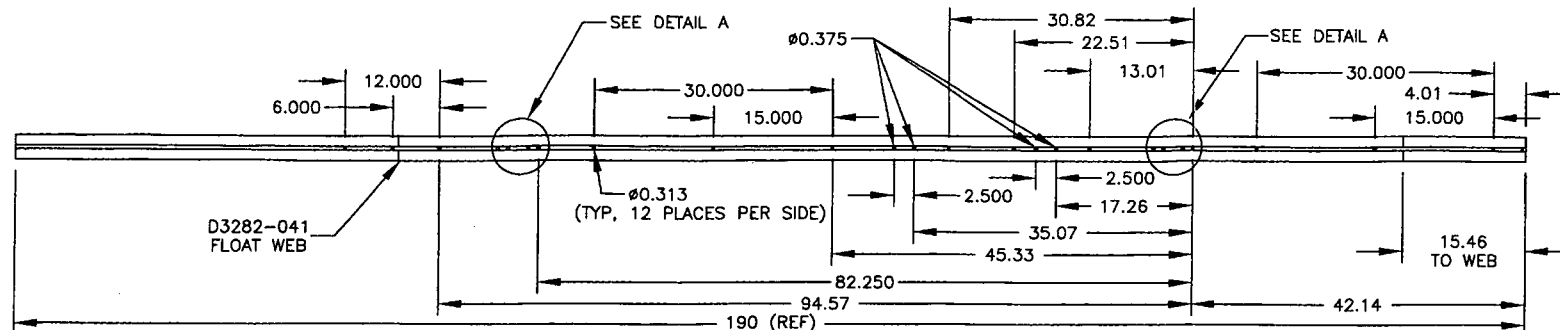
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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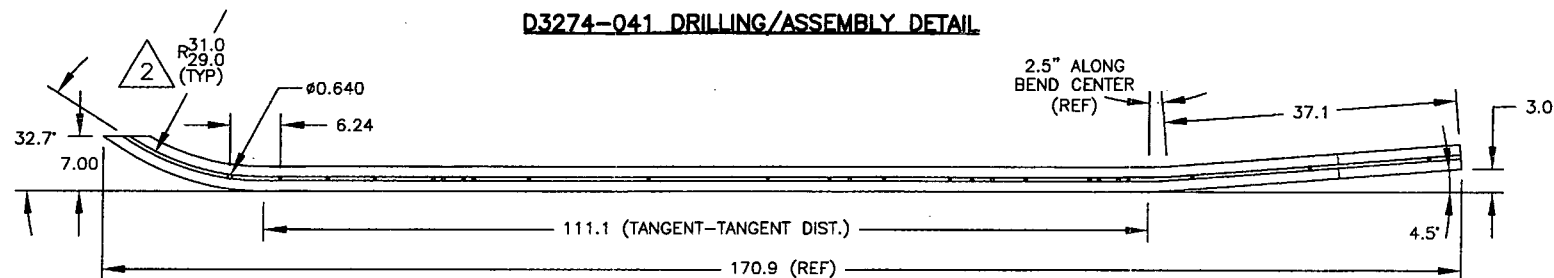
NOTE: Date & initial all entries

DEO ATTACHED

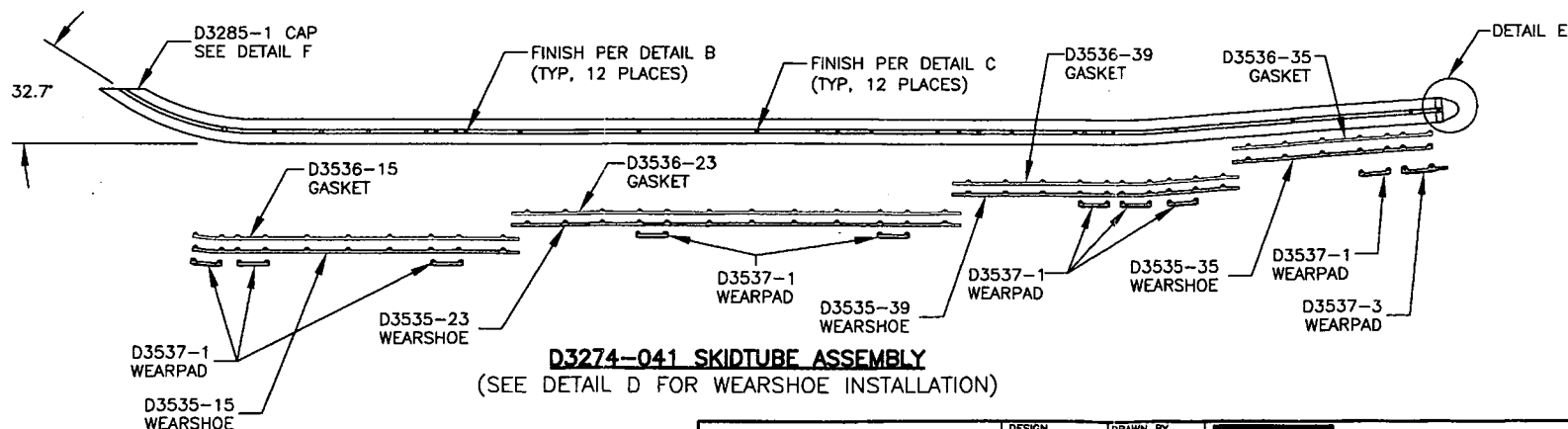
W/B 4337



D3274-041 DRILLING/ASSEMBLY DETAIL



D3274-041 BEND/DRILLING DETAIL



D3274-041 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

RELEASED

07.02.12

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|---------|----------|----------|-------------------|--|
| DESIGN | CP | DRAWN BY | PH | DART DART AEROSPACE USA, INC. PORT HADLOCK, WA |
| CHECKED | + | APPROVED | + | DRAWING NO. D3274 |
| DATE | 06.12.19 | TITLE | SKIDTUBE ASSEMBLY | REV. D SHEET 2 OF 4 SCALE 1:15 |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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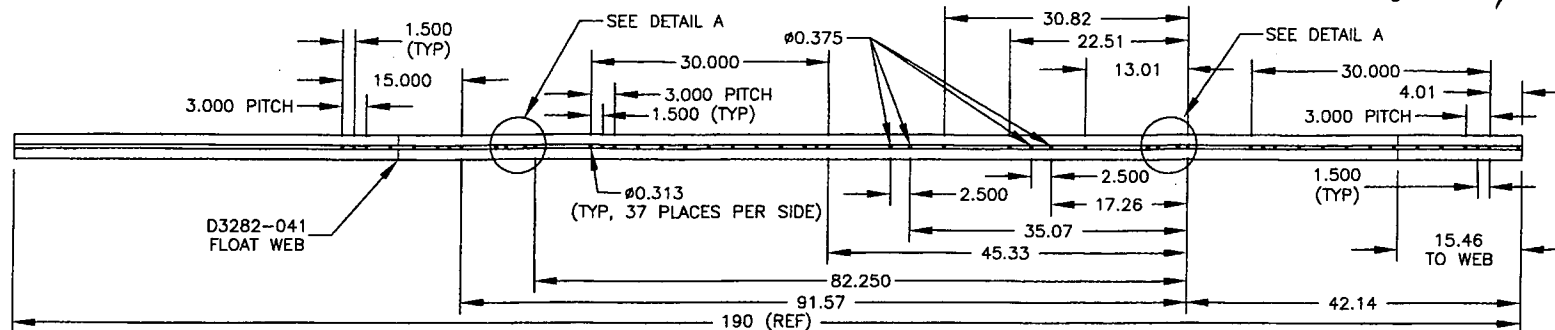
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

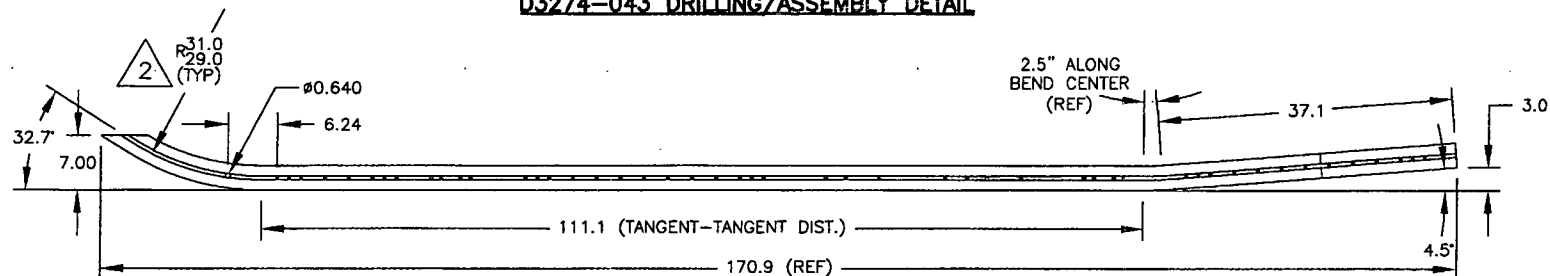
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

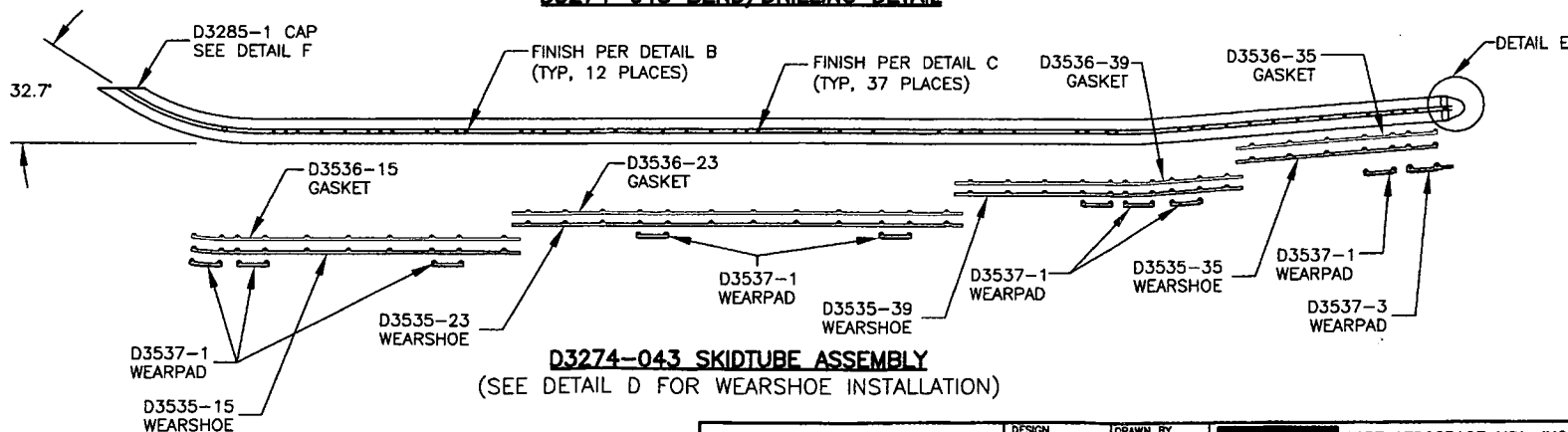
DEO ATTACHED



D3274-043 DRILLING/ASSEMBLY DETAIL



D3274-043 BEND/DRILLING DETAIL



D3274-043 SKIDTUBE ASSEMBLY

(SEE DETAIL D FOR WEARSHOE INSTALLATION)

RELEASED

07.02.12

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|---------|----------|----------|-------------------|--|
| DESIGN | CP | DRAWN BY | PH | DART DART AEROSPACE USA, INC. PORT HADLOCK, WA |
| CHECKED | H | APPROVED | H | DRAWING NO. D3274 |
| DATE | 06.12.19 | TITLE | SKIDTUBE ASSEMBLY | REV. D SHEET 3 OF 4 SCALE 1:15 |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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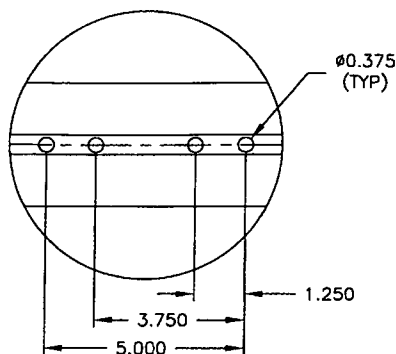
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

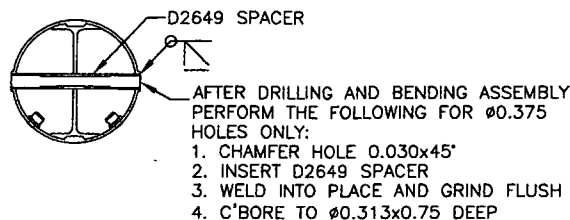
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

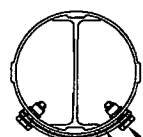
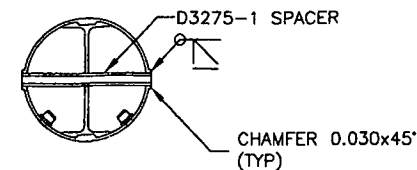
DETAIL A: DRILL DETAIL



DETAIL B FOR 0.375 HOLES ONLY



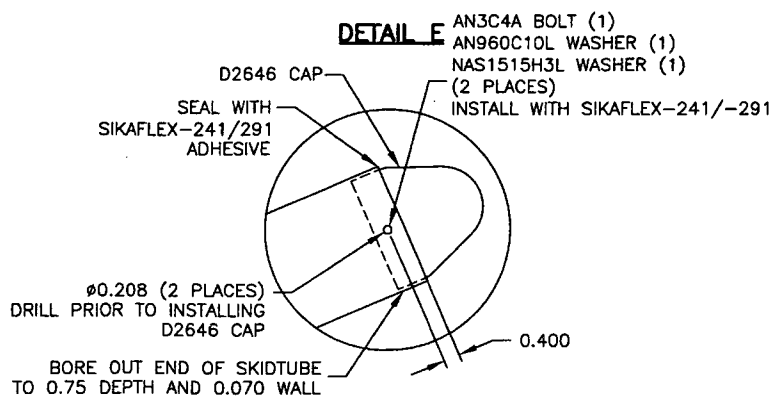
DETAIL C FOR 0.313 HOLES ONLY



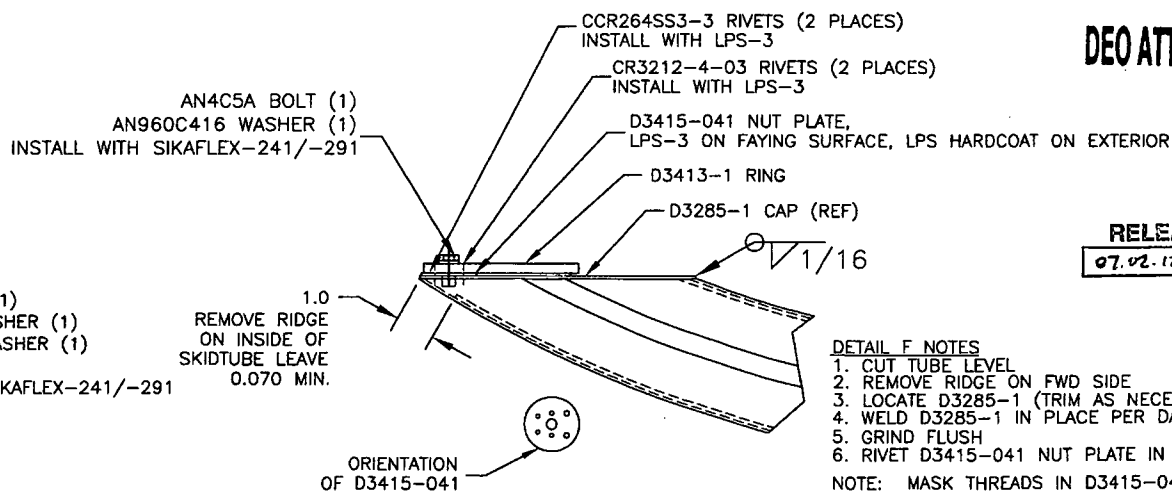
DETAIL D

ALS7-1032-130 INSERT (1)
AN3C4A BOLT (1)
AN960C10L WASHER (1)
(78 PLACES)
GASKET/WEARSHOE/WEARPAD (REF)

DETAIL E



DETAIL F: END FINISHING DETAIL



DEO ATTACHED

RELEASED
07.02.12

DETAIL F NOTES
1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE
NOTE: MASK THREADS IN D3415-041 PRIOR TO FINISH

| | | | | | |
|---|--|--------------|---------------|--|------------------------|
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| DATE 06.12.19 | | CHECKED H | APPROVED H | TITLE SKIDTUBE ASSEMBLY | SCALE 1:3 |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries ;

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|----------------------|----------------------------|---------------------|--|-------------------------|---------------------------|--------------|
| DRAWING NO. D3274 | TITLE SKIDTUBE ASSEMBLY | REV. D | DART AEROSPACE USA, INC ENGINEERING ORDER | D.E.O. NO. D3274-D-1 | SHEET NO. SHEET 1 OF 1 | SCALE NTS |
| DRAWN <i>CP</i> | CHECKED <i>1</i> | MFG. APPR. <i>1</i> | APPROVED <i>WAP</i> | DE APPR. <i>1</i> | | |
| DATE 09.06.17 | DATE 09.06.23 | DATE 09/06/23 | DATE 09/06/23 | DATE 09.06.23 | | |

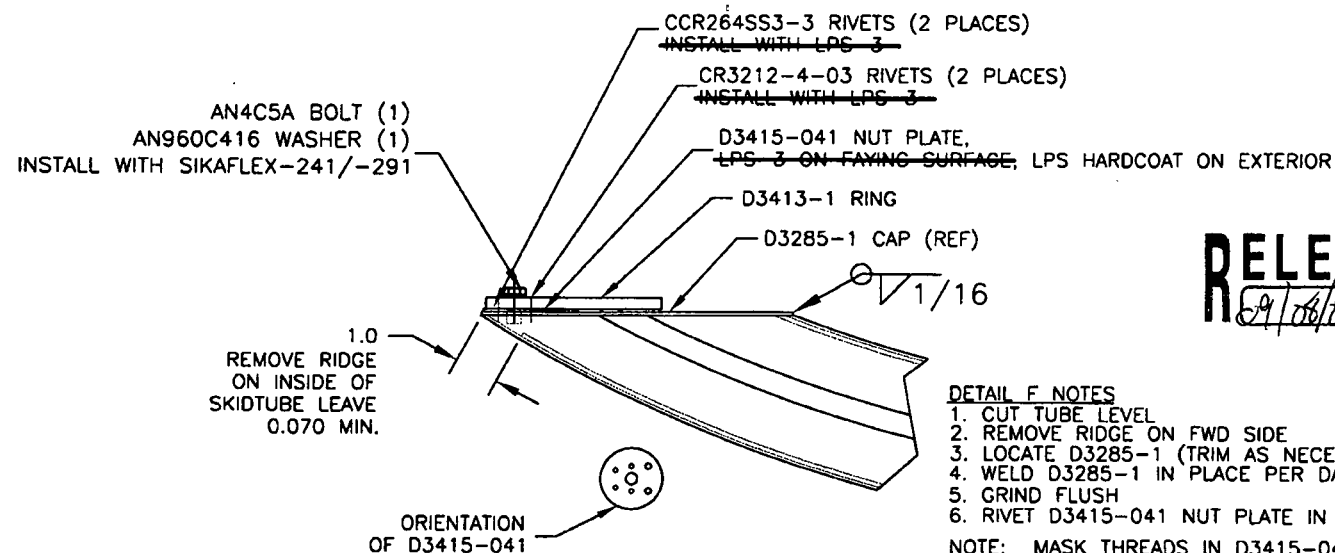
LPS-3 IS NO LONGER USED DURING ASSEMBLY OF SKIDTUBE.

AMEND NOTE 8: ~~"SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES 'LPS-3' AFTER FINISH AND INSTALLATION OF INSERTS.~~
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES 'LPS PROCYON' AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER."

AMEND DETAIL F AS SHOWN:

w/o 43374

DETAIL F: END FINISHING DETAIL



DETAIL F NOTES

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

NO. 241

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 622800
Part number: D206 442 541
Description: 206 skid
Welding Process: Tig ☒ Mig ☐
Base material: Aluminium
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual: pass ☒ fail ☐
Penetration: pass ☒ fail ☐

UNACCEPTABLE

Cracks: pass ☒ fail ☐
Undercut: pass ☒ fail ☐
Pin holes: pass ☒ fail ☐
Overlap (cold lap): pass ☒ fail ☐
Porosity (surface): pass ☒ fail ☐
Coloration: pass ☒ fail ☐

Qualifier P.D. Date of Test Coupon 10.09.30
Welder Barclay Elliott Date of Test Coupon 10.09.30

The above named individual is qualified in accordance with AWS D17.1.2001 to weld.